

5/46

|                      |              |         |
|----------------------|--------------|---------|
| DART AEROSPACE LTD   | Work Order:  | 24684   |
| Description: Bracket | Part Number: | D3146-1 |
| Dwg: D3146 Rev. A    | Qty:         | 5       |

Page 1 of 1

| Step     | Location | Procedure   | By  | Date     | Qty |
|----------|----------|---|-----|----------|-----|
| 1        | DC       | Issue Traveler  | PJ  | 05.10.26 | 5   |
| 2        | MV       | Cut blanks: 4.500" x 1.250" x 3.100" long Bar<br>Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick<br>(M6061T6B1.250x04.500)<br>Identify for D3146-1 | JL  | 05.10.29 | 5   |
| 3        | MV       | Machine as per Folio FA419 and Dwg D3146<br>Identify as D3146-1   | JL  | 05.10.30 | 5   |
| 4        | QC2      | Inspect parts as they come off the CNC machine.   | JL  | 05.10.30 | 5   |
| 5        | QC8      | Second check  | JL  | 05.10.30 | 5   |
| 6A       | MV       | Deburr and Tumble   | JL  | 05.10.30 | 5   |
| 7        | FP       | Chemical Conversion Coat as per QSI 005 4.1   | SAD | 05/11/19 | 5   |
| 8        | FP       | Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3   | JL  | 05/11/24 | 5   |
| 9        | QC3      | Inspect Powder Coat   | JL  | 05/11/25 | 5   |
| 10<br>66 | QC5      | Inspect work to Step 9  | JL  | 05/11/27 | 5   |
| 11       | ST       | Identify and Stock in Spacedoor Cell  | JL  | 05/11/25 | 5   |
| 12       | AC       | Cost / part   | JL  | 05-11-28 | 5   |
| 13       | DC       | Close W/O<br>Inspect Level 21   | JL  | 05/11/28 | 5   |

| Rev | Date     | Change    | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A   | 04.04.28 | New issue | KJ/JLM     | ✓        |

RELEASED

04/04/29

| W/O:     |      | WORK ORDER CHANGES   |    |      |     |                                     |                          |
|----------|------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 05-11-28 | 10   | QC5 should be after Step 6 for inspection of electuring, and work up to Step 6.<br><br>Permanent change. |    |      |     | <i>SB<br/>05/11/28</i>              | <i>J</i><br>05-11-28     |
|          |      |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/11/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |                                 |                 |                           |                        |                          |
|----------|------|---|-----------------------------|---------------------------------|-----------------|---------------------------|------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B |                                 |                 | Verification<br>Section C | Approval<br>Chief Eng  | Approval<br>QC Inspector |
|          |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date  |                           |                        |                          |
| 05-10-30 | 3    | - 1 part came out of vice<br>- 2 parts scrap dimension .125<br>is under tolerance | <i>SB<br/>05/11/28</i>      | - scrap & replace               | J.L<br>05-11-28 | <i>J</i><br>05-10-31      | <i>SB<br/>05/11/28</i> | <i>J</i><br>05-10-31     |
|          |      |   |                             |                                 |                 |                           |                        |                          |
|          |      |   |                             |                                 |                 |                           |                        |                          |

NOTE: Date & initial all entries

|                              |  |              |         |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD           |  | Work Order:  | 24684   |
| Description: Bracket         |  | Part Number: | D3146-1 |
| Inspection Dwg: D3146 Rev: A |  | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 3.000             | +/-0.010  | 3.003            | ✓      |        |                      |          |
| 2.000             | +/-0.010  | 2.001            | ✓      |        |                      |          |
| 0.230             | +/-0.010  | .233             | ✓      |        |                      |          |
| 0.425             | +/-0.010  | .425             | ✓      |        |                      |          |
| 3.420             | +/-0.010  | 3.421            | ✓      |        |                      |          |
| 2.535             | +/-0.010  | 2.536            | ✓      |        |                      |          |
| 0.221             | +/-0.010  | .221             | ✓      |        |                      |          |
| 0.391             | +/-0.010  | .385             | ✓      |        |                      |          |
| 0.221             | +/-0.010  | .221             | ✓      |        |                      |          |
| 0.850             | +/-0.010  | .850             | ✓      |        |                      |          |
| R0.350            | +/-0.010  | .350             | ✓      |        |                      |          |
| 0.850             | +/-0.010  | .850             | ✓      |        |                      |          |
| 0.221             | +/-0.010  | .221             | ✓      |        |                      |          |
| 0.491             | +/-0.010  | .485             | ✓      |        |                      |          |
| 0.125             | +/-0.010  | .128             | ✓      |        |                      |          |
| 1.025             | +/-0.010  | 1.019            | ✓      |        |                      |          |
| R0.375            | +/-0.010  | .375             | ✓      |        |                      |          |
| 28°               | +/-0.1°   | 28°              | ✓      |        |                      |          |
| 0.276             | +/-0.010  | .280             | ✓      |        |                      |          |
| 0.925             | +/-0.010  | .930             | ✓      |        |                      |          |
| R0.125            | +/-0.010  | .125             | ✓      |        |                      |          |
| 4.345             | +/-0.010  | 4.349            | ✓      |        |                      |          |
| 0.125             | +/-0.010  | .129             | ✓      |        |                      |          |
| 93°               | +/-0.1°   | 93°              | ✓      |        |                      |          |
| R0.125            | +/-0.010  | .125             | ✓      |        |                      |          |
| Grain Direction   | N/A       |                  |        |        |                      |          |

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L      | Audited by: | JNL      | Prototype Approval: | N/A |
| Date:        | 05.10.29 | Date:       | 05/10/29 | Date:               | N/A |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue |            | JLM      |

RELEASED

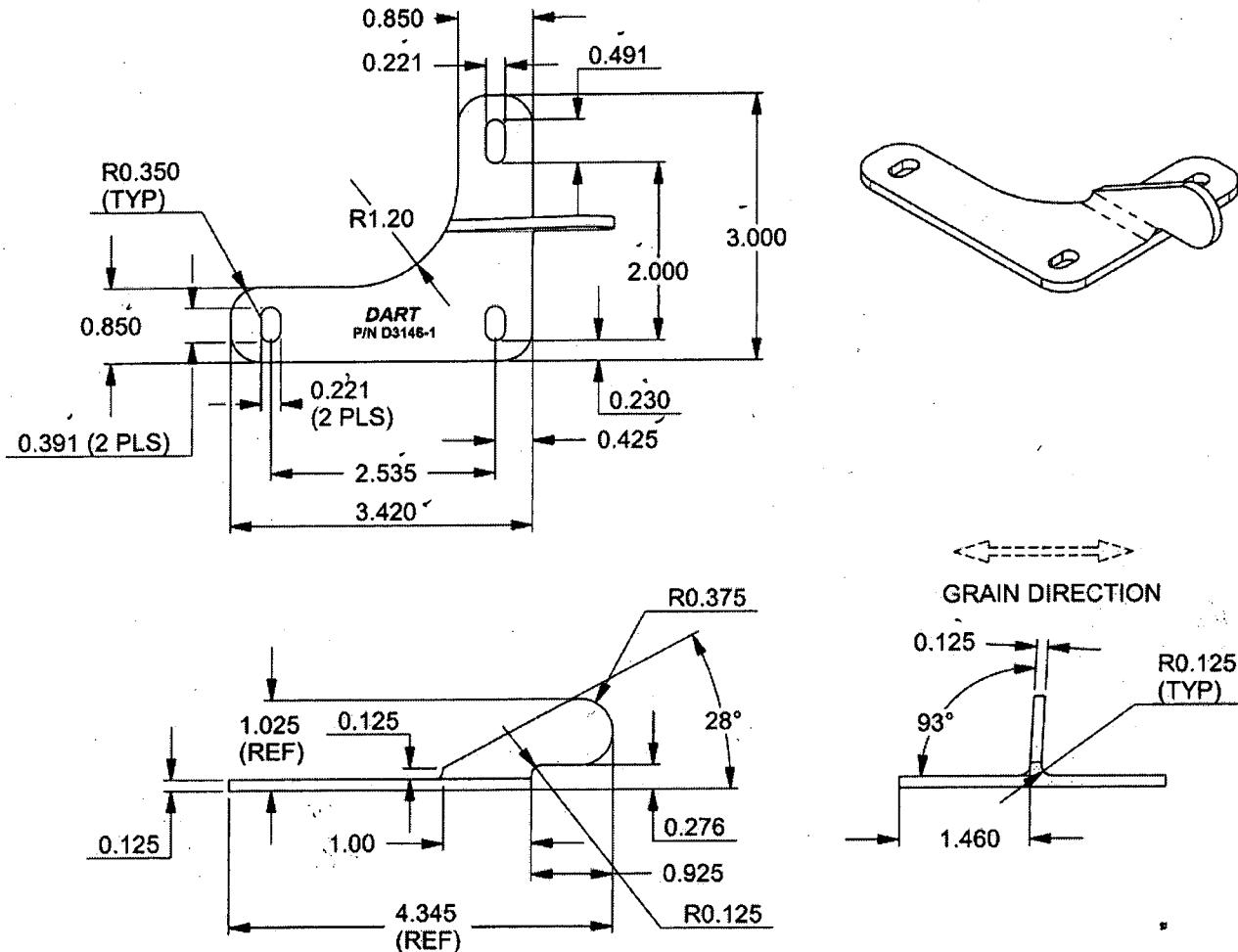
**DART**

DRAFT ISSUED

|         |          |                             |         |
|---------|----------|-----------------------------|---------|
| DESIGN  | DRAWN BY | DART AEROSPACE LTD          |         |
|         | RF       | HAWKESBURY, ONTARIO, CANADA |         |
| CHECKED | APPROVED | DRAWING NO.                 |         |
|         |          | D3146                       | REV. A  |
| DATE    | 02.04.25 | TITLE                       | BRACKET |
|         |          | SCALE                       | 1:2     |

RELEASED  
02.05.27

A 02.04.25 NEW ISSUE



D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27  
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

24684

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## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyOct 25, 2005  
04:04 pm

Work Order No : 0024684  
 Project Name : D3146-1  
 Project For : WK546  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3146-1  
 Description : Hinge Bracket  
 Manufactured : Yes  
 Amount Req'd : 5  
 Amount Done : 0  
 Start Date : 10-25-05  
 Est Finish Date : 11-15-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

|                   | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours         | 0.00      | 0.00   | 0.00   |        |         |
| CNC               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours       | 0.00      | 0.00   | 0.00   |        |         |
| Misc.             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost        | 0.00      | 0.00   | 0.00   |        |         |
| Mark up           | 0.000     | 0.000  |        |        |         |
| Selling Cost      | 0.00      | 0.00   |        |        |         |

|                        | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Done | 0.00      | 0.00   |
| Profits/ (Loss)        | 0.00      | 0.00   |

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyNov 08, 2005  
12:44 pm

Work Order No : 0024684  
 Project Name : D3146-1  
 Project For : WK546  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3146-1  
 Description : Hinge Bracket  
 Manufactured : Yes  
 Amount Req'd : 5  
 Amount Done : 0  
 Start Date : 10-25-05  
 Est Finish Date : 11-15-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Margin : 0.000%  
 Actual Margin : 0.000%

|                     | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours : | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost :  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours :  | 0.00      | 16.50  | 100.00 |        |         |
| Production Cost :   | 0.00      | 287.14 | 100.00 | 0.00   | 287.14  |
| Packaging Hours :   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost :    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours :    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours :         | 0.00      | 16.50  | 100.00 |        |         |
| CNC :               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours :       | 0.00      | 0.00   | 0.00   |        |         |
| Misc. :             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| =====               |           | =====  | =====  |        |         |
| Burden :            | 0.00      | 0.00   | 0.00   |        |         |
| =====               |           | =====  | =====  |        |         |
| Total Cost :        | 0.00      | 287.14 | 100.00 |        |         |
| Margin :            | 0.000     | 0.000  |        |        |         |
| Selling Cost :      | 0.00      | 287.14 |        |        |         |

|                          | Estimated | Actual     |
|--------------------------|-----------|------------|
| Labour Hrs/Amount Done : | 0.00      | 0.00       |
| Profits/ (Loss) :        | 0.00      | ( -287.15) |

MS D/B  
 u  
 W/B

Date: Monday, 14/11/2005 8:12:09 AM  
 User: Alba Panzuto

## Process Sheet

|                       |                                       |  |                  |                              |  |  |
|-----------------------|---------------------------------------|--|------------------|------------------------------|--|--|
| Customer              | : CU-DAR001 Dart Helicopters Services |  | Drawing Name     | : BRACKET                    |  |  |
| Job Number            | : 24684                               |  | Part Number      | : D31461                     |  |  |
| Estimate Number       | : 10393                               |  | Drawing Number   | : D3146 REV A                |  |  |
| P.O. Number           | :                                     |  | Project Number   | :                            |  |  |
| This Issue            | : 14/11/2005 S.O. No. :               |  | Drawing Revision | : A                          |  |  |
| Prsht Rev.            | : NC                                  |  | Material         | :                            |  |  |
| First Issue           | : / / Type : MACHINED PARTS           |  | Due Date         | : 30/11/2005 Qty: 5 Um: Each |  |  |
| Previous Run          | :                                     |  |                  |                              |  |  |
| Written By            | :                                     |  |                  |                              |  |  |
| Checked & Approved By | :                                     |  |                  |                              |  |  |
| Comment               | : Est A04.04.28 New issue KJ/JLM      |  |                  |                              |  |  |

## Additional Product

Job Number:



| Seq. #:   | Machine Or Operation: | Description :                          |
|---|-----------------------|--|
| 1.0   | M6061T6B1250X04500    | 6061-T6 Bar 1.25" X 4.5"               |
| 2.0   | BAND SAW              | BAND SAW                               |
|   |                       |  |
| Comment: BAND SAW                               |                       |  |
| Cut blanks: 4.500" x 1.250" x 3.100" long Bar   |                       |  |
| 3.0   | HAAS1                 | HAAS CNC VERTICAL MACHINING #1         |
|   |                       |  |
| Comment: HAAS CNC VERTICAL MACHINING #1         |                       |  |
| Machine as per Folio FA419 and Dwg D3146        |                       |  |
| Identify as D3146-1                             |                       |  |
| 4.0   | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE |
|   |                       |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE |                       |  |
| 5.0   | QC8                   | SECOND CHECK                           |
|   |                       |  |
| Comment: SECOND CHECK                           |                       |  |
| 6.0   | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1          |
|   |                       |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1          |                       |  |
| Deburr and Tumble                               |                       |  |
| 7.0   | HAND FINISHING1       | HAND FINISHING RESOURCE #1             |
|   |                       |  |
| Comment: HAND FINISHING RESOURCE #1             |                       |  |
| Chemical Conversion Coat as per QSI 005 4.1     |                       |  |

Date: Monday, 14/11/2005 8:12:10 AM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 24684

Part Number: D31461

Job Number:



Seq. #: Machine Or Operation:

Description :

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect work to Step 9

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

